



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA3-2
Job Sheet 188945



Part No: SWA3-2

Job Qty: 1 ea

Part Name: Electric Swivel 3,000 lb Safe Work Load (1,360 Kg)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/11/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG SWA3 Rev 3

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	2/11/19	2/11/19	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs	2/11/19	2/11/19	0.00	2.00	Small Fab-6		AD / MICHEL
120	QC	1 pcs	2/11/19	2/11/19	0.00	0.00	QC5		DAS 8 5 6
125	DC	1 pcs	2/11/19	2/11/19	0.00	0.00	DC		21 JAN 22 2019
130	Packaging	1 pcs	2/11/19	2/11/19	0.00	0.00	Packaging3		DAS 8 5 6
140	QC21-FG	1 Ea	2/11/19	2/11/19	0.00	0.00	QC21		21 JAN 22 2019

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA3 swivel manual*** Engrave Descriptions: T/N And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

125 - Photocopy blue file OM & OOPM-SWA3A Rev3

130 - Bag and tag

GREASE AEROSHELL NO. 7 (M138724) LOCTITE 242 (M138766)
SILICONE GE (M138994)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-832-3/8	Set Screw	1 Ea (1 ea)	90-Start up Operation	5027242
92210A303	Flat Socket Cap Screw	4 pcs (4 ea)	110-Small Fab	5135587
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5135581
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5066781
EL314-SJTOW	Long Line Electrical Wire, 14/3 Gauge	6 ft (6 ea)	110-Small Fab	5047767
SWA3-100	Upper End - Swa3 Swivel	1 pcs (1 ea)	110-Small Fab	5108526
SWA3-200	Lower End	1 pcs (1 ea)	110-Small Fab	5029398
SWA3-300	Wire Clamp	2 pcs (2 ea)	110-Small Fab	5134854
SWA3-400	Button Head Screw	2 Ea (2 ea)	110-Small Fab	5142694
SWA3-500	Connector Bushing-230	1 pcs (1 ea)	110-Small Fab	5117115
SWA3-600	O-Ring	1 pcs (1 ea)	110-Small Fab	5142445
SWA3-700	9529K15 Bearing Balls - 1/4"	32 Ea (32 ea)	110-Small Fab	5097699
SWA6A-1900	1/4" Female Spade Connector	4 Ea (4 ea)	110-Small Fab	5097738
SWA6A-900A	Rotary Connector - 2 wire	1 pcs (1 ea)	110-Small Fab	5126634

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-832-3/8	1	40	0
110-Small Fab	92210A303	4	108	0
	EL-PLUG-F	1	23	0
	EL-PLUG-M	1	38	0
	EL314-SJTOW	6	380	0
	SWA3-100	1	4	0
	SWA3-200	1	1	0
	SWA3-300	2	35	0
	SWA3-400	2	15	0
	SWA3-500	1	21	0
	SWA3-600	1	17	0
	SWA3-700	32	120	0
	SWA6A-1900	4	347	0
	SWA6A-900A	1	10	0
Part Specifications				
Specifications could not be found.				

Plex 1/17/19 7:07 AM dart.lacelle.linda

DAKI
 AEROSPACE
 1270 Aberdeen Street
 Hamden, CT 06517
 TEL: 203 632-5200
 Email: sales@dakiaero.com
 www.dakiaerospace.com
 Container No: S145875
 Part: SWA3-2
 Job No: 188945
 Serial No/ Batch: S145875
 Revision: 0
 Inspector:
 Exp Date:
 Instructions:

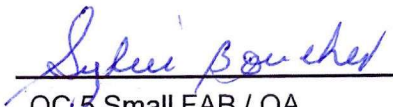
Date: 01/17/19

Work Order 188945

Customer _____

Number of Wires 2Date 2019/01/21Serial Number S145875

Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	3,000	Check for Conductivity against all wires.	- PASS
1	3,000	Check all wires for grounding against swivel body.	- PASS
1	1,500	Check for Conductivity against all wires.	- PASS
1	1,500	Check all wires for grounding against swivel body.	- PASS
1	750	Check for Conductivity against all wires.	- PASS
1	750	Check all wires for grounding against swivel body.	- PASS
1	0	Check for Conductivity against all wires.	- PASS
1	0	Check all wires for grounding against swivel body.	- PASS

Test Conducted By: ALAN PATRY
TechnicianSignature: 
QC5 Small FAB / QASubmit

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>188945</u> Part No. <u>SWA### Swivels</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐																				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																					
Date : <u>2019/01/21</u>		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Feb 01, 2018																	
Description Work Order Deviation - Use a combination of heatshrink tubing and RTV Silicone to create a watertight seal around all electrical connections. - Use a D2728-1 Placard in place of the laser engraved Dart logo				Disposition These deviations are acceptable to carry out on the following swivels: - SWA3 - SWA6A - SWA10A - SWA15A - SWA25A - PSWA25A There is no impact on fit, form or function.				Completed By <u>ALAN PATRY</u> Lead hand / Supervisor Approval Verification															
				QC / QA Coordinator Approval																			

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☒	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☒	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☒	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER : _____			